

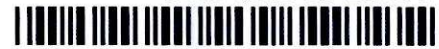


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.2511

Job Sheet 211971



PRIORITY

Part No: 647.2511

Job Qty: 4 pcs

Part Name: Nut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/20

Job Tracking No:

Due Date: 8/25/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.2500 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD IPP REV:B 19.02.27 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

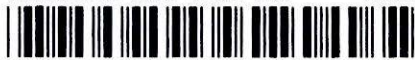
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
100	Doosan - 1	4 pcs	8/14/20	8/14/20	1.00	1.91	Doosan - 1		33	20/08/01
110	QC 2	4 pcs	8/14/20	8/14/20	0.00	0.00	QC 2 - 1		9-89	
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33		DAS	
							QC 2 - 35		33	20/08/01
							QC 2 - 39		9-89	
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S291456



Part: 647.2511

Job No: 211971

Serial No/Batch: S291456

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/01/20

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
140	QC 8	4 pcs	8/14/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
150	Outsource - 17 - Passivate	4 pcs	8/25/20		GRO002-VC 7
160	Packaging 2-1 - Receive - B4B	4 pcs	8/25/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B

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A.E 20-08-05

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				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
170	QC 6	4 pcs	8/25/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
180	Packaging 3-1 - Stock - B4B	4 pcs	8/25/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B

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				Packaging 3 - 37 - B4B	
190 QC 21 - SA	4 pcs	8/25/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-25
				QC 21 - SA - 77	

AUG 14 2020

Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB144 AND DWG DWG Rev: A FOLIO Rev: AA -Deburr per dwg
 Descriptions: ***CHECK THREADS USING GO/ NO GO GAUGE*****

110 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check) 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

150 - Issue P/O: 46843 Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required

160 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached

170 - QC6- All purchased or subcontracted products

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.000	17-4 SS Round Bar 1,000"	.2000 ft (.05 ea)	100-Doosan - 1	<u>5285031</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-H1150-R1.000 <u>R1.500</u>	0	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nut	0.875Inches ± 0.010	0.885 0.865		
2	Nut	0.530Inches ± 0.010	0.540 0.520		
3	Nut	90.000Degrees ± 0.500	90.500 89.500	Angle	
4	Nut	0.660Inches ± 0.010	0.670 0.650		
5	Nut	0.130Inches ± 0.010	0.140 0.120		
6	Nut	0.580inches + 0.000 - 0.002	0.580 0.578		
7	Nut	0.590Inches ± 0.010	0.600 0.580		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046843



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046843

PO Date: 8/5/20

Due Date: 8/12/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-08-05

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211970	647.2510	647.2500 Rev A	Sleeve : Various STC's Issue P/O: Passivate as per MIL-S-5002 TYPE 6 Certificate of Conformity is required	Firmed - X4	-	8/12/20	4 pcs	0 pcs AUG 13 2020	4 pcs	\$12.50/pcs	\$50.00
2	211971	647.2511	647.2500 Rev A	Nut : Various STC's Issue P/O: Passivate as per MIL-S-5002 TYPE 6 Certificate of Conformity is required	Firmed - X4	-	8/12/20	4 pcs	0 pcs AUG 13 2020	4 pcs	\$12.50/pcs	\$50.00
Grand Total:												\$100.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 8/5/20 9:30 AM Dart. Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



0 3 0 0 7 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

030079 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
06-Aug-2020		Ian Wilson			POHB046843			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.2510 Rev.	647.2510 01 -PASSIVATION NITRIC #1/ DICHRIMATE [PASSIVATION NITRIC #1/ DICHRIMATE] AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	4	4	0	0	0
2	647.2511 Rev.	647.2511 01 -PASSIVATION NITRIC #1/ DICHRIMATE [PASSIVATION NITRIC #1/ DICHRIMATE] AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	4	4	0	0	0

DAS
81
9-86

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DAS
81
9-80

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.